Work Order ID 110824 \*110824\* Page 1 January-07-14 3:08:54 PM Item ID: D3535-13 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Stainless Steel Wearplate Fwd Start Qty: 6.00 **Start Date:** 1/07/14 **Cust Item ID:** Required Date: 1/07/14 Req'd Oty: 6.00 **Customer:** Reference: Start Run Process Plan: MLJ Date: 14-01-08 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Insp. Accept **Work Center ID** Description **Qty Qty Run Hours** Code Number Stamp Draw Nbr Revision Nbr D3535 Rev B 100 0.00 FLOW WATER JET 13 R 14-1-29 \*100\* 0.00 Waterjet Memo 1-Cut as per Dwg D3535 Dwg Rev: \$\int\$ FLOW CNC Waterjet Prog Rev: Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110 \*110\* 0.00 OC Memo Quality Control DAS 27 120 QC8- Inspect parts - second check

\*120\*

Quality Control

Memo

DQA:			Date:										TQAG
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DEI	PARTMENT	PROCESS	
	-					Rework	1 <b> </b>		Skid-tube Crosstube			Water Jet	Engineering
Part I	No.					Scrap	1 1		Machining Small Fab	$\vdash$	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1	Therm	noforming Finishing		Rec/Sto	e/Packaging	Other
NCR I	۷o.					Suspected Unapproved	]	:	Large Fab Composite		:	Supplier	
Post				1	Docc	ription of work order update		nitial	Action		Sign &	1	
Root Cause		Date	Step	Qty	Desci	or non-conformance	1	ief Eng	Description		Date	Verification	QC Inspector
Design	$\dashv$	Date	step	Qty		of floti-conformance		ilei Liig	Description		Date	Vermeation	QC IIISPECTOI
Doc/Data	Н												
Equip/Tooling	Н												
Handling/Pre	Н												
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Operator		-					1						
Offset/Setup	П												
Process													]
Supplier													
Training													
Transport													
Unapproved					<u> </u>								
							FA	ULT CAT	regory				<del></del>
Landi					_	General	_	1			1 .	<u></u>	<b>–</b>
	Н	Bending	_			Bend		1	rogram	<u> </u>	Outside Dim	ļ	Pressure/Forced
	Н	Centre No	ot Concer	ntric	-	BOM/Route	-	Grain		-	Over/Under		Set-up
	Н	Cracks	1 (5: 1		<u> </u>	Broken/Damage/Defect		Hardwa		$\vdash$	Part Incorre	<b>⊢</b>	Temperature/Cure
	Н	Crimp/Kir	ık/kipple	, wave		Burrs	$\vdash$	1 '	ion Incomplete/Unqualified	<u></u>	Part Lost/Mi	·	Weld
	$\vdash$	Crushing			-	Contamination Countersink	$\vdash$	4	ions Incomplete/Unclear gned/off center	$\vdash$	Part Moved Positioned V		Wrong Stock Pulled
		Crushing Heat Trea	.+		$\vdash$	Cut Too Short	$\vdash$	Mislabe		$\vdash$	Power Loss/		Other
	H	Inspection		Tube	-	Drawing	$\vdash$	Misrea			1. ower 1033/	Juige	Tomer
	$\vdash$	Marks/Ch		iune	$\vdash$	Drill Holes	$\vdash$	Off-set					
	$\vdash$	Turning S			-	Finish	$\vdash$	4					
		Linthius 2	eauence			IFILISH		IUUT OT	Calibration				

W	ork	Order	ID	110824
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## \*11000/1\*

Page 2

January-07-14	3:08:54 PM	•		* 1 1 (	10/4"						
Item ID:	D3535-13			Accept	*N900	040	100	)* :	Setup Star	t *N	S1*
Revision ID:								_	Stop		
Item Name:	Stainless Ste	eel Wearplate Fwd	25						500	×1/7	S2*
Start Date:	1/07/14	Start Qty: 6.00	*6*		Cust Item I	D:					
Required Date	: 1/07/14	<b>Req'd Qty:</b> 6.00	*6*		<b>Customer:</b>						
Reference:								_	n 04		
Approvals:	Process P	lan:	Date:	Tooling:	Da	nte:		J	Run Star	~1 <i>\</i> J	R1*
	QC:		Date:	SPC (Y/N):	Da	nte:			Stop	, *N	R2*
Sequence ID/ Work Center I	<b>D</b>	Operation Description	and the same	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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*130*		NC BRAKE				DAS 30		13			1.70
Brake NC		Memo		0.00		9-89		<del></del>			
Brake NC				using Jigs DT8261and DT T8158Identify as D3535-							. <b>, ,</b>
. 140		QC5- Inspect part comp	leteness to step on W/O	0.00 DAS							
		QCS Inspect part comp	ictorious to stop on w, o	27							
*14 <b>0*</b>		Memo		0.00	17						_

150

\*150\* Powdercoat

**Quality Control** 

Powder Coating

0.00

Memo

0.00

OVEN TEMPERATURE:

13-6 14-2-5, 333

DQA:			Date:											
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UF	PDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	·r·					DISPOSITION		1		AGAINST DE	PARTMENT	/PROCESS		
WOLK OTGE	•				-	Rework	1		Skid-tube	Crosstube	1	Water Jet	_	Engineering
Part N	ı					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	$\dashv$	Quality
Taiti	٠				-	Use-as-is			noforming	Finishing	4	re/Packaging	$\dashv$	Other
NCR N	lo.					Suspected Unapproved	]	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Large Fab	Composite	]	Supplier		
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Root		<b>.</b>	<b> </b>		Desci	ription of work order update	1	nitial	Acti		Sign &	Varification		OC Inconcetor
Cause	-	Date	Step	Qty		or non-conformance	Cn	ief Eng	Descri	iption	Date	Verification	1	QC Inspector
Design	$\dashv$						ļ							
Doc/Data	$\dashv$													
Equip/Tooling Handling/Pre	_													
· ·														
Material Operator														
Offset/Setup														
Process														
Supplier									:					
Training														
Transport		:												
Unapproved										•				
							FA	ULT CA	TEGORY					
Landi	ng (	Gear	· · · · · ·			General		_			_	_		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	nqualified	Part Lost/Mi	issing		Weld
		Cuffs				Contamination		4	tions Incomplete/L	Jnclear	Part Moved	l		Wrong Stock Pulled
		Crushing				Countersink		-	gned/off center		Positioned V	r		
	<u></u>	Heat Trea				Cut Too Short	L	Mislab			Power Loss/	Surge		Other
	Ļ	Inspectio		Tube	L	Drawing	<u></u>	Misrea						
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,	_	Turning S				Finish	_	4	Calibration					
	l	Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence					

Work Ord January-07-14		0824		*110	1824*						Page 3
Item ID: Revision ID: Item Name:	D3535-13 Stainless Stee	il Wearplate Fwd	-	Accept	*N900	<u>ი</u> 40	100	<b>)*</b> s	Setup Sta	17	S1* S2*
Start Date: Required Date Reference:	1/07/14 : 1/07/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:				7 -	17
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:	_	F	kun Sta	<sup>rt</sup> *N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*1 60* QC Quality Control		QC3- Inspect Part Finish  Memo		0.00				B	<u>1409</u>	-05	DAS 9 9-89
<sup>170</sup> <b>*17∩*</b>		Identify as per dwg & Stoc	k Location: $\sqrt{10-00}$	2 0.00				_x13	d	Id	14/02/0

0.00

0.00

MLJ 140205 MLJ 140205

Packaging

\*1 20\*

Quality Control

QC21- Final Inspection - Work Order Release

Memo

180

Work Order:    Date   Disposition   Disposit	DQA:			Date:										•	$\mathcal{L}_{\mathcal{A}}$
Work Order:    Part No.	_			_			<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
Part No.	QA Closed:			Date:							W	ork Order up	date only		
Rework Scrap Use-as-is Suspected Unapproved  Root Cause Date Step Otty Or non-conformance Design Handling/Pre Hadring Handling/Pre Haterial Ogerator Offset/Setup Process Supplier  Fault CATEGORY  Landing Gear Carcks Car	Work Orde	r:					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS		
Part No. Use-as-is Suspected Unapproved Use-as-is Suspection Unappro	Work Grace	· · -					Rework	1		Skid-tube Crosstube			Water Jet	٦	Engineering
NCR No.    Suspected Unapproved   Sign & Sign & Verification   QC Inspector	Part No	ο.					—			<b>—</b>		Prod	<u> </u>	┪	<del></del>
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Handling/Fre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Unapproved Description Description Description Description Date Verification QC Inspector  FAULT CATEGORY  FOR Not Concentric General Outside Dimensions Over/Under tolerance Set-up Farance Control C		-					Use-as-is	1	Thern	noforming Finishing		Rec/Stor	e/Packaging		Other
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data	NCR N	o					Suspected Unapproved	]		Large Fab Composite		]	Supplier		
Design	Root					Desc	ription of work order update		nitial	Action		Sign &	· · · · · · · · · · · · · · · · · · ·	T	
Doc/Data Equip/Tooling Handling/Pre Material Offset/Setup Process Supplier Training Transport Unapproved    Bending Gear   General   Bending Gear   General   Centre Not Concentric   BOM/Route   Grain   Over/Under tolerance   Set-up   Crimp/Kink/Ripple/Wave   Burrs   Inspection Incomplete/Unqualified   Part Lost/Missing   Weld   Contamination   Instructions Incomplete/Unclear   Part Moved   Wrong Stock Pulled   Wrong Wrong   Wrong Wr	Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	┙	QC Inspector
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Transport ' Unapproved	Supplier	_													
Landing Gear   General   Folio/Program   Outside Dimensions   Pressure/Forced   Over/Under tolerance   Set-up   Cracks   Broken/Damage/Defect   Hardware   Part Incorrect   Temperature/Cure   Crimp/Kink/Ripple/Wave   Cuffs   Contamination   Instructions Incomplete/Unqualified   Part Moved   Wrong Stock Pulled   Cushing   Countersink   Misaligned/off center   Positioned Wrong   Positioned Wrong   Countersink   Counters	Training	_												ŀ	
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Crushing Countersink Misaligned/off center Positioned Wrong		$\neg$	•	кукірріе	y wave		1	$\vdash$	1 '	• • •	$\vdash$	-1	SSING		
		┙				-		$\vdash$	4	• •	$\vdash$	-1	/rong		WITCHE STOCK FUHEU
	-		_	·+		-	Cut Too Short	-	-1		$\vdash$	=	_	٦.	Other
Inspection Strip in Tube Drawing Misread	-	$\dashv$			Tube	-	-1	-	4		<u></u>	Ti owei ross/s	Juige [		OUI-CI
Marks/Chatter Drill Holes Off-set	}	_	-	-	rube	$\vdash$	<b>⊣</b> ~	$\vdash$	-						
Turning Sequence Finish Out of Calibration		ᅱ				<u> </u>	1	-	-			<b></b>			
Wave/Twist in Tube Fit/Function Out of Sequence		$\dashv$				-	4	$\vdash$	-i						

January-07-14 3:08:53 PM

Work Order ID:

110824

Parent Item:

D3535-13

Parent Item Name:

Stainless Steel Wearplate Fwd

**Start Date:** 1/07/14

Required Date: 1/07/14

Start Qty: 6.00

Required Qty: 6.00

**Comments:** 

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	298.5500	0.8505	5.3715792 Q /47		· · ·	
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT020		298.55							

7.75 290.8

DQA:			Date:										TRACT
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	·
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS	
	-					Rework	1		Skid-tube Crosstub	e	1	Water Jet	Engineering
Part N	lo.					Scrap	1	1	Machining Small Fa	ıb 🗀	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1 1	Thern	noforming Finishir	ng	Rec/Stor	e/Packaging	Other
NCR N	10.					Suspected Unapproved	]		Large Fab Composit	te	]	Supplier	
Root	_				Dosc	ription of work order update	Н	nitial	Action	-	Sign &		i .
Cause	1	Date	Step	Qty	Desci	or non-conformance	1	ief Eng			Date	Verification	QC Inspector
Design	-	Date	Step	Qty		or non comormance	-	iler eng	Description				Qu'inspecto.
Doc/Data													
Equip/Tooling						•					ļ		
Handling/Pre													
Material												•	
Operator				ļ t									
Offset/Setup													
Process			İ										
Supplier													
Training					Į.				,				
Transport													
Unapproved			1										
							FA	ULT CA	TEGORY				
Landi	_	1			F	General		1 ,,			1		٦,
	<u> </u>	Bending			-	Bend	$\vdash$	4	Program	┝	Outside Dim	<del> </del>	Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	-	Grain		$\vdash$	Over/Under	_	Set-up Temperature/Cure
	$\vdash$	Cracks	ale/Dimm! -	/\A/~	-	Broken/Damage/Defect	-	Hardwa		$\vdash$	Part Incorred Part Lost/Mi	<b>—</b>	Weld
		Crimp/Kir	пк/кірріе	e/wave	-	Burrs	-	1 '	ion Incomplete/Unqualified	.  -	Part Moved	<u> </u>	<b>=</b>
	_	Crushing			$\vdash$	Contamination   Countersink	$\vdash$		tions Incomplete/Unclear gned/off center	-	Positioned V	<u></u>	Wrong Stock Pulled
	-	Crushing Heat Trea			-	Cut Too Short	-	Mislabe		$\vdash$	Power Loss/		Other
	<u> </u>	Inspectio		Tube	$\vdash$	Drawing	-	Misrea		L	J. 044CI 2033/	<u>-</u>	Totalei
	$\vdash$	Marks/Ch		Tube	-	Drill Holes		Off-set				. <del></del>	
		Turning S				Finish	$\vdash$	-1	Calibration		<del></del>		
		Wave/Tw	•			Fit/Function		4	Sequence				

DART AEROSPACE LTD	Work Order:	110824
Description: Wearshoe	Part Number:	D3535-13
Inspection Dwg: D3535 Rev: B		Page 1 of 1

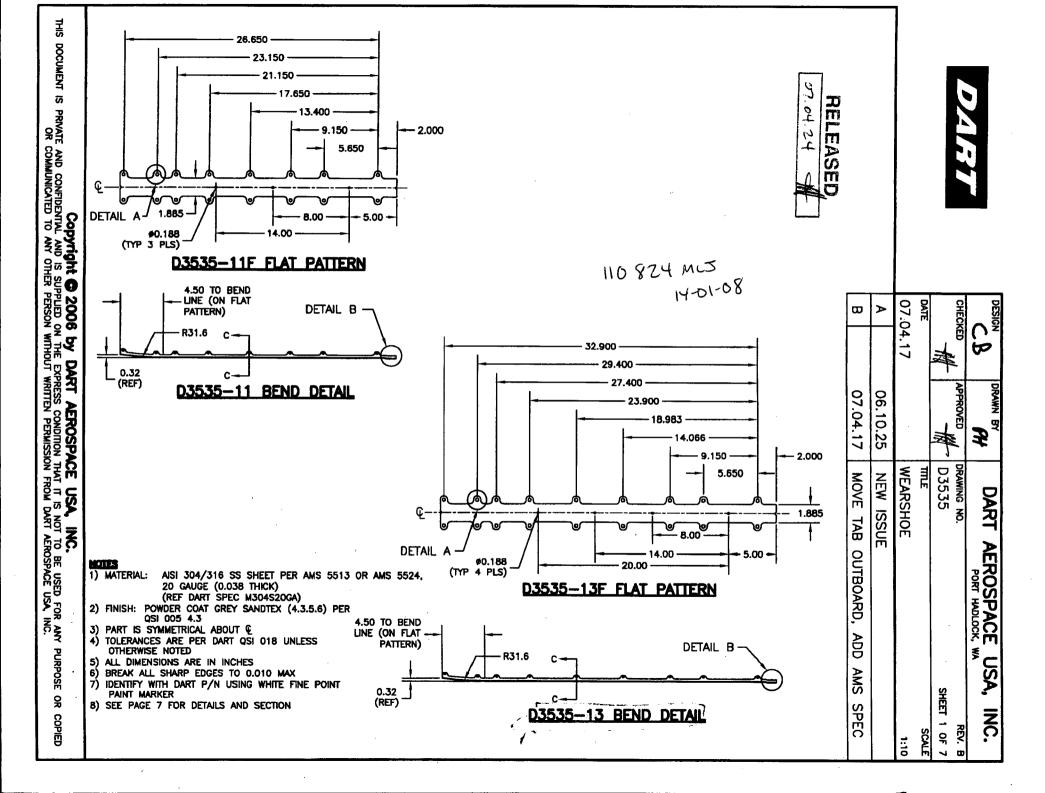
## FIRST ARTICLE INSPECTION CHECKLIST

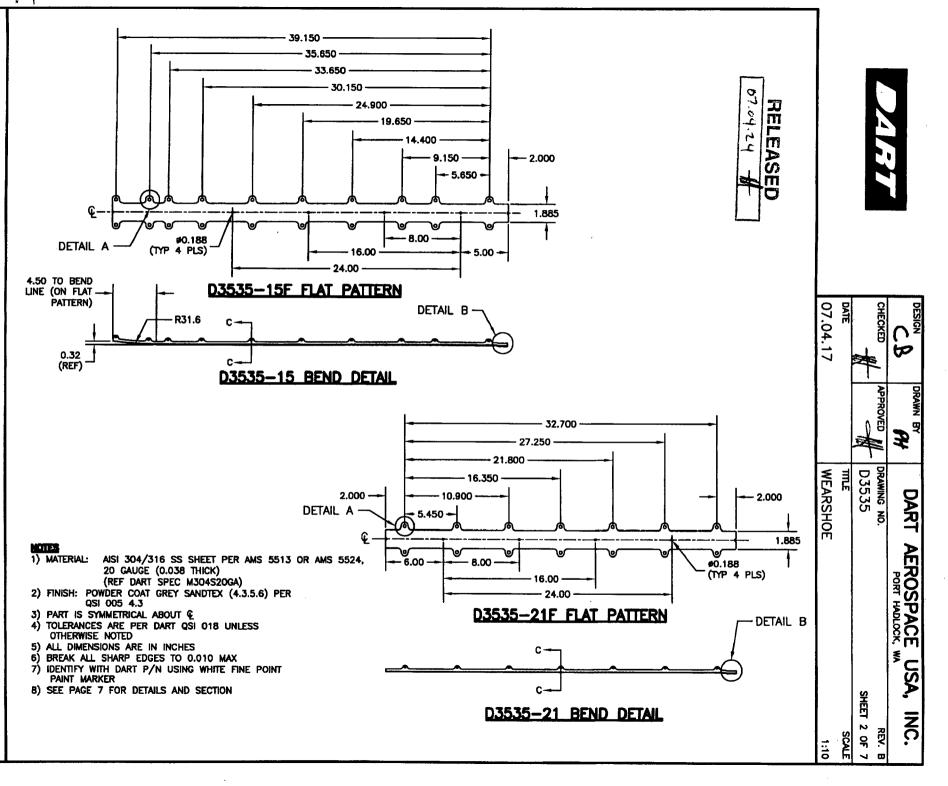
X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.895	/	ν	Struck	
2.000	+/-0.010	2.01	/			•
5.650	+/-0.010	5.654				
9.150	+/-0.010	9.150				
14.066	+/-0.010	14.06				
18.983	+/-0.010	18-98				
23.900	+/-0.010	23.9				
27.400	+/-0.010	27.9	V			
29.400	+/-0.010	29.4	V		-	
32.900	+/-0.010	32.9				
Ø0.188	+0.005/-0.001	0/93				
20.00	+/-0.030	20	سي			
14.00	+/-0.030	14 -	-			
8.00	+/-0.030	8				-
5.00	+/-0.030	5			***	
0.300	+/-0.010	0302				
0.300	+/-0.010	0.308				
0.038	+/-0.010	0.355	/		- 17-20	

Measured by:	Q,	Audited by:	DAS 27	Prototype Approval:	N/A
Date:	14-1-29	Date:	141129	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD X	<b>X</b>





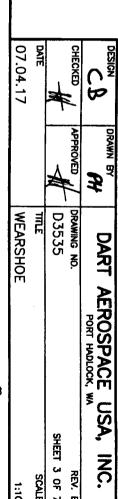
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COPIED

코 등



Ä

CHECKED

APPROVED

DRAWING NO.

SHEET

4 OF 7

SCALE 1:10

B

3

DART

AEROSPACE PORT HADLOCK.

RO.

07.04.17

WEARSHOE







D3535-31F FLAT PATTERN

22.500 19.000

> DETAIL A ≠0.188 (TYP 3 PLS)

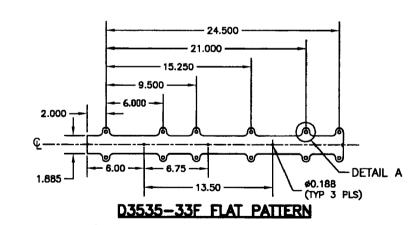
14.250

9.500

6.000 -

2.000

1.885



MOTES	
1) MATERIAL:	
	20 GAUGE (0.038 THICK)
	(PEE DART SPEC MROASSOCA)

(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



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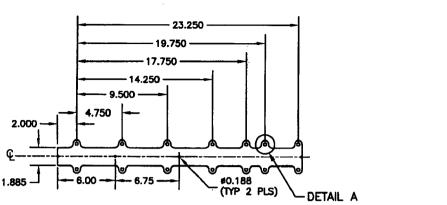
DATE

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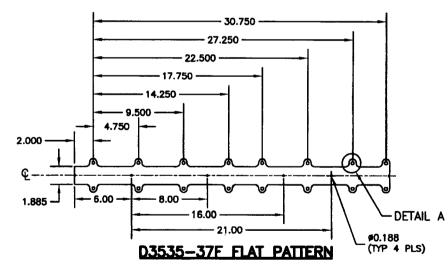
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RELEASE



## D3535-35F FLAT PATTERN





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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

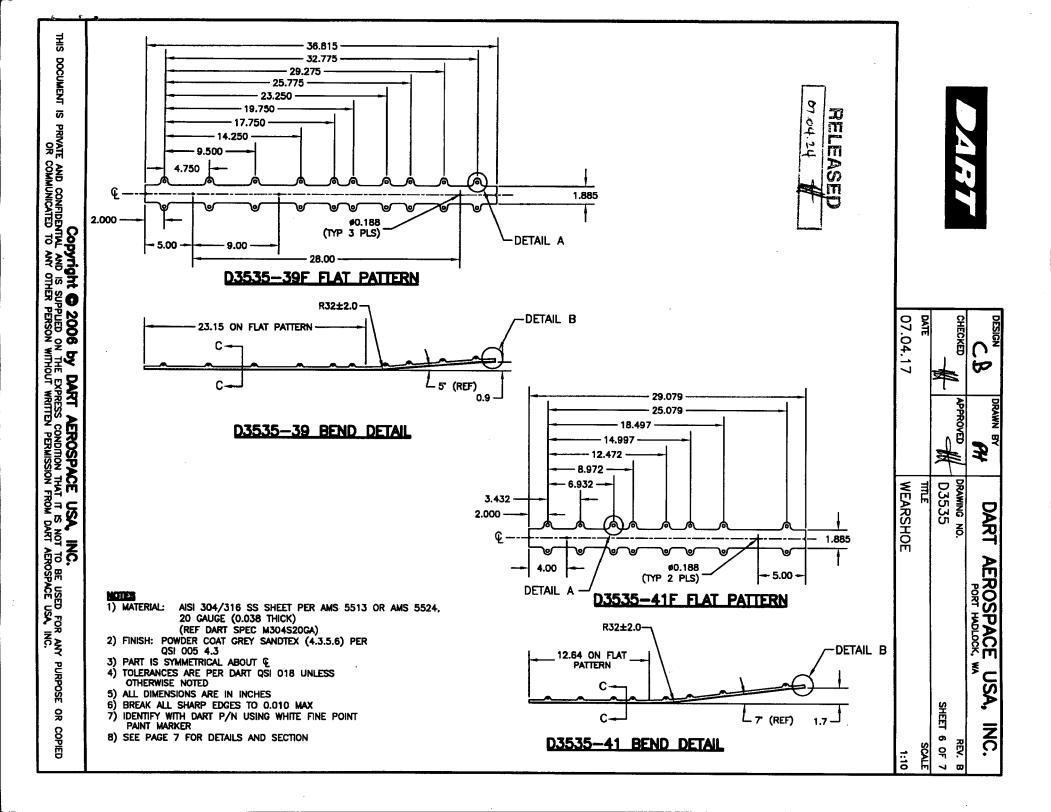
5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

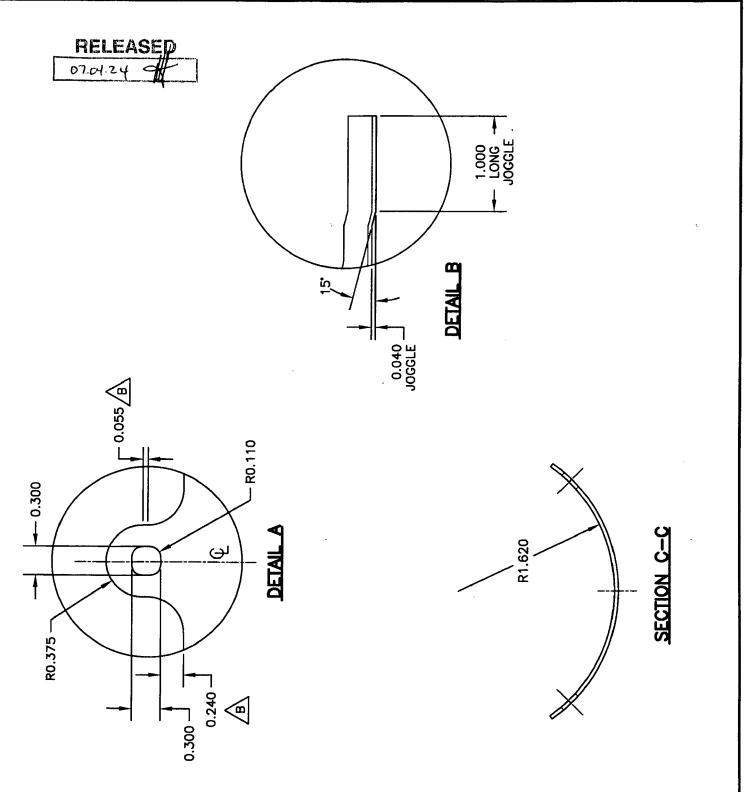
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		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
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